

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86522

86522

Page 2

Wednesday, July 04, 2012 8:10:29 AM

Item ID: D3783-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lateral Brace Assembly

Stop ***NS2***

Start Date: 7/4/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/6/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

124

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

124

Powdercoat

Memo

0.00

Powder Coating

Mask inside D3765-1 clevis

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

Black
Sandtex
2:00
3200 F
2:30

2X

m-l
12/07/04

127

QC3- Inspect Part Finish

0.00

127

QC

Memo

0.00

Quality Control

2

12/12-7-4

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

Q

So
12/07/04

m-l 12/27/09

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Work Order ID 86522

Wednesday, July 04, 2012 8:10:29 AM

86522

Page 3

Item ID: D3783-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Lateral Brace Assembly

Stop ***NS2***Start Date: 7/4/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 7/6/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

OK 12/7/6

MF
12-07-05

Dart Aerospace Ltd

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Picklist Print

Wednesday, July 04, 2012 8:10:28 AM

Page 1

Work Order ID: 86522
Parent Item: D3783-041
Parent Item Name: Lateral Brace Assembly

Start Date: 7/4/2012 Required Date: 7/6/2012
Start Qty: 2.00 Required Qty: 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.a as per dwg DD verified by:EC IPP RevC: add powder coat for ease of manufacturing DD 10.01.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-13A Bolt		Purchased	No			110	Each	86.0000	2	4		7/12/07/04	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	10						
						116003	10						
						ST338	76						
						108167	8						
						118983	2						
						121181	50						
						15928	16						
AN960JD516 Washer	NAS1149D0563J	Purchased	No			110	Each	12.0000	4	8		7/12/07/04	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST338	12						
						2612	12						
D3765-1 Clevis		Manufactured	No			110	Each	8.0000	2	4		7/12/07/04	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST243	4						
						83374	4						
						ST250	4						
						81698	4						
D3769-1 Tube		Manufactured	No			110	Each	8.0000	1	2		7/12/07/04	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST251A	8						
						86038	8						

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Picklist Print

Wednesday, July 04, 2012 8:10:29 AM

Page 2

Work Order ID: 86522

Parent Item: D3783-041

Parent Item Name: Lateral Brace Assembly

Start Date: 7/4/2012

Required Date: 7/6/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

110

Each

1,224.0000

2

4

Nut

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

724

108827

4

116105

5

116548

43

117611

2

119109

658

17651

4

2937

8

[Handwritten signature]
7/12/07/04

4

Dart Aerospace Ltd

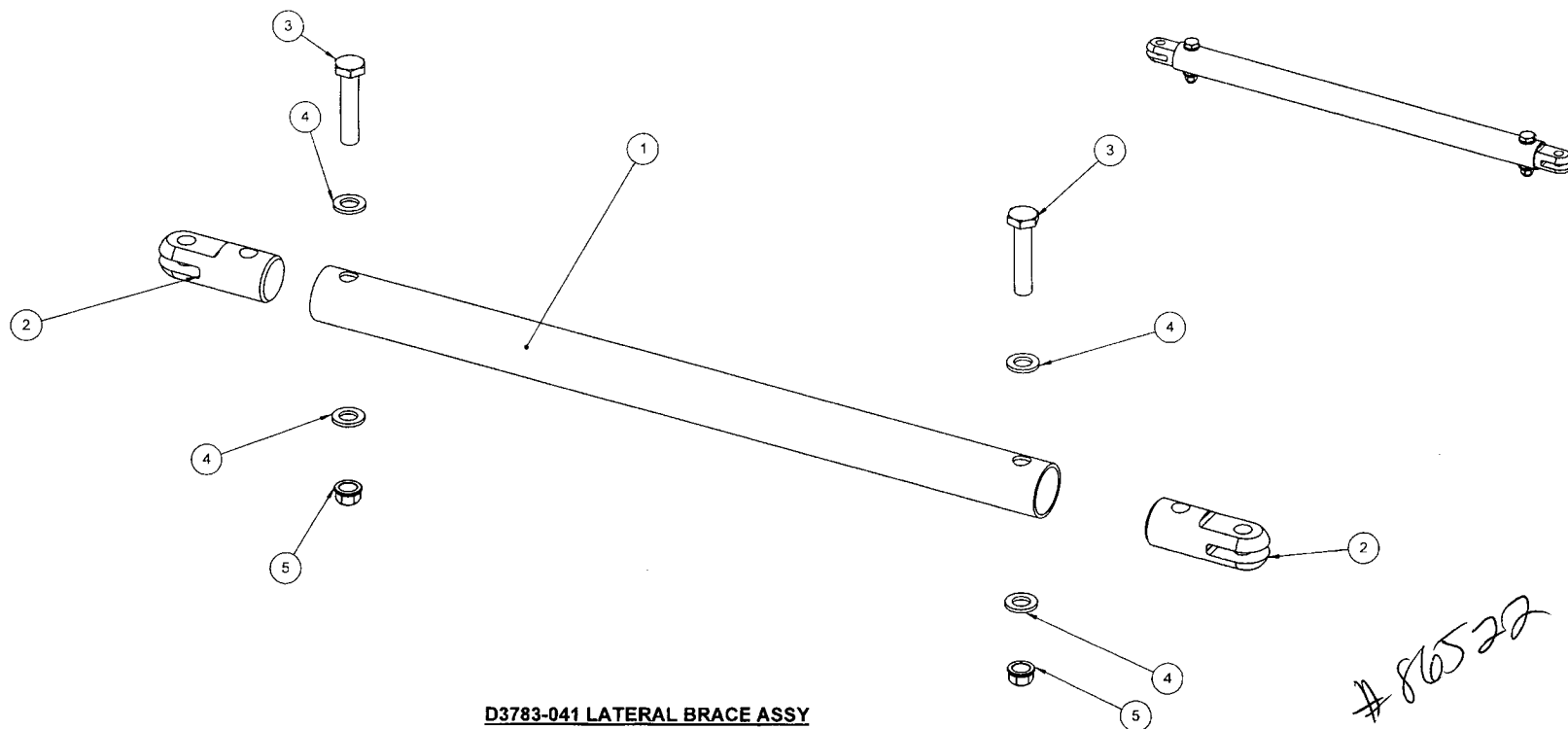
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D3783-041 LATERAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3769-1	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.52 lbs

RELEASED
08.06.16/10

A		NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION			BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 3	
DRAWN	HS				
CHECKED		DRAWING NO. D3783			
MFG. APPR.		TITLE BRACE ASSEMBLY		SCALE NTS	
APPROVED		DATE 08.06.04			
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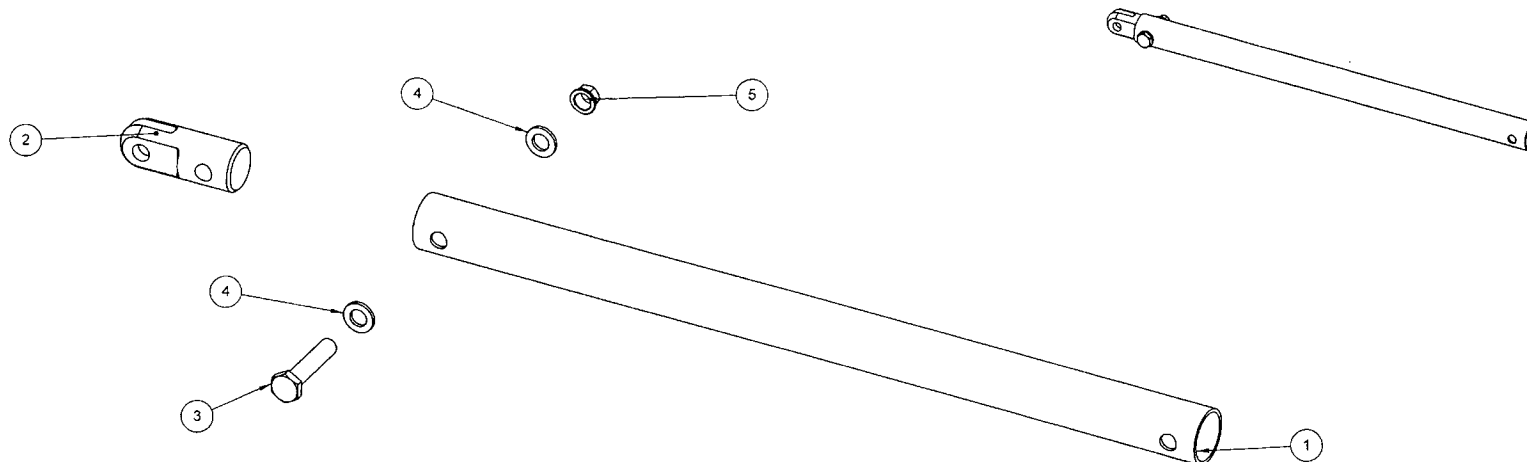
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3783-043 LONGITUDINAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3769-3	TUBE	1
2	D3765-1	CLEVIS	1
3	AN5-13A	BOLT	1
4	NAS1149D0568J	WASHER (AN960JD516)	2
5	MS21042L5	NUT	1

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

86522

RELEASED
08-06-04

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3783	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACE ASSEMBLY	NTS
DATE	08.06.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

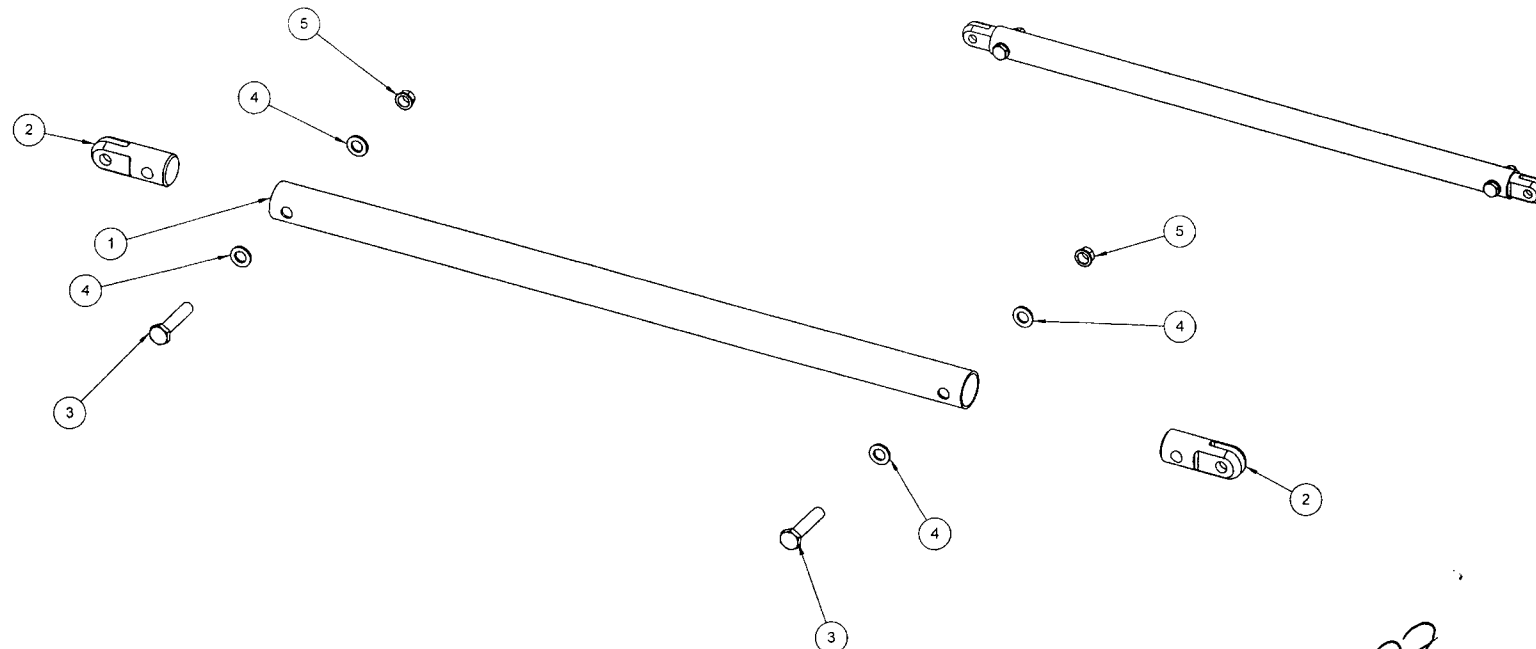
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D3783-045 ANGLE BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3769-5	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.63 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3783 REV. A SHEET 3 OF 3 TITLE BRACE ASSEMBLY SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>
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DE APPR.		
DATE	08.06.04	

#86522

RELEASED
08-06-14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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